

Reprint



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D3414-041
Job Sheet 201421



Part No: D3414-041

Job Qty: 16 pcs

Part Name: Lug



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/3/19

Job Tracking No:

Due Date: 11/25/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP A 05.09.13 New issue KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
140	Large Fab - Welded Assy-1	16 pcs	11/25/19	11/25/19	0.00	3.20	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		MV Nov 25/19
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
150	QC 9	16 pcs	11/25/19	11/25/19	0.00	0.00	QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		H2
							QC 9 - 9		
160	QC 5	16 pcs	11/25/19	11/25/19	0.00	16.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		



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Container No: S234369



Job No: 201421

Job No: 201421

Job No/Batch: S234369

Division:

Director:

					QC 5 - 9	
					QC 5 - 50	EZ
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
170 Powdercoat - 2 White GI(S)- B4B	16 pcs	11/25/19	0.00 0.34	Powdercoat - 1 - B4B		
				Powdercoat - 2 - B4B		
				Powdercoat - 3 - B4B		BK 19-11-29
				Powdercoat - 4 - B4B		
180 QC 3	16 pcs	11/25/19	0.00 16.00	QC 3 - 10		
				QC 3 - 13		
				QC 3 - 15		
				QC 3 - 17		
				QC 3 - 18		
				QC 3 - 2		
				QC 3 - 28		
				QC 3 - 3		
				QC 3 - 30		
				QC 3 - 34		
				QC 3 - 36		
				QC 3 - 41		
				QC 3 - 51		
				QC 3 - 58		
				QC 3 - 59		
				QC 3 - 68		
				QC 3 - 9		
				QC 3 - 40		
				QC 3 - 19		DAS NOV 3 0 2019 40 9-89
				QC 3 - 43		
				QC 3 - 24		
				QC 3 - 61		
				QC 3 - 81		
190 Packaging 3-1 - Stock - B4B	16 pcs	11/25/19	0.00 16.00	Packaging 3 - 1 - B4B		
				Packaging 3 - 2 - B4B		
				Packaging 3 - 3 - B4B		
				Packaging 3 - 4 - B4B		
				Packaging 3 - 5 - B4B		
				Packaging 3 - 6 - B4B		
				Packaging 3 - 7 - B4B		
				Packaging 3 - 8 - B4B		
				Packaging 3 - 9 - B4B		
				Packaging 3 - 10 - B4B		
				Packaging 3 - 11 - B4B		
				Packaging 3 - 12 - B4B		
				Packaging 3 - 13 - B4B		
				Packaging 3 - 14 - B4B		
				Packaging 3 - 15 - B4B		
				Packaging 3 - 16 - B4B		
				Packaging 3 - 17 - B4B		
				Packaging 3 - 18 - B4B		
				Packaging 3 - 19 -		
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				B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	PC STS31
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
200 QC 21 - SA	16 pcs	11/25/19	0.00 16.00	QC 21 - SA - 21	DAS 21
				QC 21 - SA - 70	3.00
				QC 21 - SA - 53	DEC 04 2019

Part Op 140 - (Weld per dwg A/R S.S. rod Batch M138974) 1- Weld using location Jig DT9625 as per Dwg D3414 A/R S.S.
 Descriptions: welding rod Batch: M138974
 150 - (QC9- Inspect visual per QSI004- Fusion Welds)
 160 - (QC5- Inspect part completeness to step on W/O)
 170 - (White Gloes/Ref 4.3.5.2) per QSI005 4.3-Steel) START TIME: 1:20 M211886 OVEN TEMPERATURE: 1100
 FINISH TIME: 1:50
 180 - (QC3- Inspect Part Finish)
 190 - (Identify as per dwg & Stock Location: _____)
 200 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3414-3	Lug	16 pcs (1 ea)	140-Large Fab - Welded Assy-1	5230378
D3414-1	Lug Bracket	16 pcs (1 ea)	140-Large Fab - Welded Assy-1	525084 / 5229382

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
140-Large Fab - Welded Assy-1	D3414-1	16	31	0
	D3414-3	16	30	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Lug Bracket	0.313inches + 0.006 - 0.001	0.319 0.312		
2	Lug Bracket	1.190inches ± 0.030	1.220 1.160		
3	Lug Bracket	1.000inches ± 0.030	1.030 0.970		
4	Lug Bracket	3.380inches ± 0.030	3.410 3.350		
5	Lug Bracket	5.350inches ± 0.010	5.360 5.340		
6	Lug Bracket	6.230inches ± 0.030	6.260 6.200		
7	Lug Bracket	2.500inches ± 0.010	2.510 2.490		
8	Lug Bracket	0.370inches ± 0.030	0.400 0.340		
9	Lug Bracket	0.100inches ± 0.010	0.110 0.090		

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